



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6405G00332-3G-PO
Job Sheet 194373



Part No: RBW6405G00332-3G-PO **Job Qty:** 2 pcs

Part Name: Tail Rotor Pitch Control Adjustment Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/1/19

Job Tracking No:

Due Date: 6/26/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6405G00332-3G Rev.5 IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs	6/26/19	6/26/19	0.00	0.00	Purchasing - 1		DP JUN 07 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	2 pcs	6/26/19	6/26/19	0.00	0.00	Packaging 2 - 1 - B4B		DP JUN 07 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S188531



Part: RBW6405G00332-3G

Job No: 194373

Serial No/Batch: S188531

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 06/07/19

				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120 QC 6	2 pcs	6/26/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
121 Small Fab - 2 - B4B	2 pcs	6/26/19	0.00 0.00	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
122 QC 5	2 pcs	6/26/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
130 Packaging 3-1 - Stock - B4B	2 pcs	6/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	

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				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	6/26/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

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JUN 27 2019

Part Op 100 - (Purchasing) Issue P/O: HB043342 MANUFACTURE RBW6405G00332-3G AS PER DWG Supplier: METEC
 Descriptions: Certificate of conformity is required

110 - (Receive & Inspect for Damage & Mat'l Certs)

120 - (QC6- All purchased or subcontracted products)

121 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 as per DWG sheet 5. 3-Install placard using drive screws.

122 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

x 2 *[Signature]*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6405G00332-3GP	Tail Rotor Pitch Control Adjustment Tool	2 pcs (1 ea)	100-Purchasing	<i>5/88530</i>
90081A077	Drive Screw #2 1/4" Long	8 Ea (4 ea)	121-Small Fab - 2 - B4B	<i>N/R</i>
RB41011	Dart Tooling Placard, Aluminum	2 pcs (1 ea)	121-Small Fab - 2 - B4B	<i>5021040</i>

Job Allocations

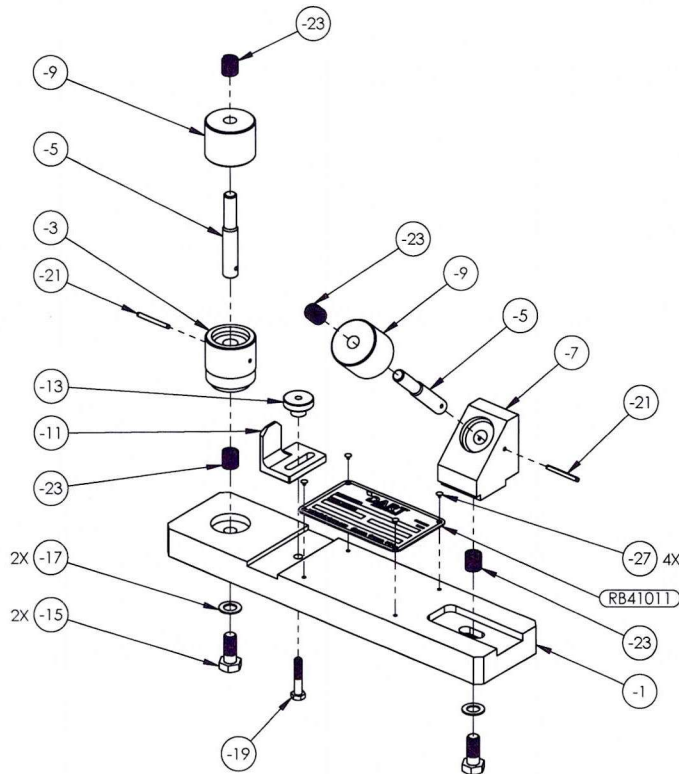
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6405G00332-3GP	2	0	0
121-Small Fab - 2 - B4B	90081A077	8	82	0
	RB41011	2	338	0

Part Specifications

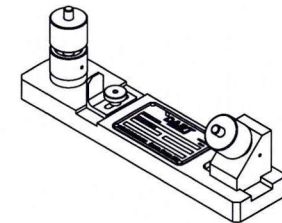
Specifications could not be found.

Plex 5/1/19 10:39 AM dart.Lussier.Patrick

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
A		-1 CHD ENGRAVE NOTE.	5/28/2009	RJC
1		-1 CHD LOWER C.B. FROM Ø.981. ADDED MISSING DIM 1.375. CHD FINISH SPEC. DELETED ENGRAVE NOTE. -8 CHD FINISH SPEC. ADDED MISSING HOLE DIM. -7 ADDED MISSING DIM FOR HOLE & CHD DIMS FOR HOLE LOCATION. DELETED .754 DIM. ADDED ENGRAVE NOTE, CHD FINISH SPEC. -3, -9 & -11 ADDED ENGRAVE NOTE, CHD FINISH SPEC.	5/4/2011	RJC
2		-1 ADDED 4X Ø.089 HOLES. CHD FROM POWDER COAT TO RED ANODIZE. -3 CHD B/O INFO FROM Ø1.378 TO Ø1.1/4. CHD O.D. FROM 1.230 TO 1.25. -7 ADDED MISSING R.062 DIM. ADDED 1.584 AND .370 DIMS.	9/24/2012	JAG
3		-1 REMOVED MASKING ANNOTATIONS AND ASSOCIATED NOTES. -5 CHD DIM WAS Ø.372 BASIC IS Ø.374 AND LIMITS. -7 ADDED LIMITS TO Ø.374 DIM. ADDED LOCATION DIM FOR Ø.098 HOLE (1.057).	2/5/2013	BIM
4	15-0298	-3 CHD ENGRAVE NOTE WAS ENGRAVE T/N IS ENGRAVE P/N. CHD DIM WAS Ø.094 IS Ø.097 - .094. -5 CHD DIM WAS Ø.094 IS Ø.097 - .094. CHD MATERIAL CALLOUT WAS 4140 G&P IS 4140 G&P / 4142. -7 CHD ENGRAVE NOTE WAS ENGRAVE T/N IS ENGRAVE P/N. CHD DIM WAS Ø.094 IS Ø.097 - .094. -9 CHD ENGRAVE NOTE WAS ENGRAVE T/N IS ENGRAVE P/N. -11 CHD ENGRAVE NOTE WAS ENGRAVE T/N IS ENGRAVE P/N.	9/14/2015	JAG
5	16-0233	-1 CHD DIMS WAS Ø.323 THRU L. J Ø.978 ±.20 S.F. -3 IS Ø.323 THRU ALL L. J Ø.9780.9792 ±.20 (S.F. -3). WAS .986 S.F. -11 IS .986 ±.002 (S.F. -11). WAS .988 S.F. -7 IS .988 ±.002 (S.F. -7). WAS 1.375 IS (1.375). DELETED DIMS .427, 2X R.196 ±.20, 2X Ø.98 ±.40, 2X R.164 THRU, 3.690. ADDED DIMS .24, .40, .235, .392, 2X FULL R. 328, .90, 2X FULL R. 2X Ø.20. -3 CHD DIMS WAS Ø.374 S.F. -5 IS Ø.3738-.3747 (S.F. -5). WAS Ø.094-.097 IS Ø.094-.097 THRU ALL (P.F. -21). WAS Ø.328 FOR -23 HELICOID IS TAP FOR -23 5/16-24 HELICOID INSERT = 1.5" DIA. WAS Ø.977 S.F. -1 IS Ø.9756-.9764 (S.F. -1). -5 CHD DIMS WAS Ø.374-.0012-.0019 Ø.3721-.3728 (S.F. -3 & -7). WAS Ø.094-.097 THRU IS Ø.094-.097 THRU ALL (P.F. -21). WAS .914 IS .914 ±.010. CHD MATL WAS 4140 G&P / 4142 G&P IS 4140/4142. ADDED HEAT TREAT RC 28-34. CHD FINISH WAS CAD PLATE YELLOW QQQ-1416. TYPE III. CLASS II IS ZINC PLATE ASTM B633 TYPE I SC2. -7 CHD DIMS WAS Ø.234 THRU ALL L. J Ø.374 ±.0007-.0000 ±.75 S.F. -5 IS Ø.234 THRU ALL L. J Ø.3738-.3747 ±.75 (S.F. -5). WAS Ø.094-.097 THRU IS Ø.094-.097 THRU ALL (P.F. -21). WAS Ø.328 ±.0012-.0019 Ø.3721-.3728 (S.F. -3 & -7). WAS Ø.094-.097 THRU IS Ø.094-.097 THRU ALL (P.F. -21). WAS .980 ±.002 (S.F. -1). WAS .430 IS (430). -9 CHD DIM WAS Ø.328 THRU ALL FOR -23 HELICOID IS TAP FOR -23 5/16-24 HELICOID INSERT = 1.5" DIA. -11 CHD DIM WAS .981 S.F. -1 IS .980 ±.002 (S.F. -1). DELETED DIM R.103. ADDED DIMS .206, 2X FULL R. -27 CHD B/O REF WAS Ø.1 X 1/8 #90081A074 IS #2 X 1/4 (#90081A077).	11/28/2016	DPD



NOTES:
ORIGINAL REF. No.
RBW6405G00332 ASSY. = 3G6405G00332
RBW6405G00332-1 = 3G6405G01252
RBW6405G00332-3 = 3G6405G06431
RBW6405G00332-7 = 3G6405G06531
RBW6405G00332-9 = 3G6405G06631
RBW6405G00332-11 = 3G6405G01652
DO NOT USE, FOR REFERENCE ONLY

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	6061		2
			-3	1	ROUND SEAT	6061		3
			-5	2	STUD	4140/4142		4
			-7	1	SLIDE SEAT	6061		5
			-9	2	KNOB	6061		6
			-11	1	POINTER	6061		7
		B/O	-13	1	THUMB NUT	S.S.	#10-32 UNF (ESSENTRA #SKN-55)	1
		B/O	-15	2	HEX HEAD CAP SCREW	STEEL	5/16-24 UNF (SPENCER AIRCRAFT #AN5-5A)	1
		B/O	-17	2	FLAT WASHER	STEEL	Ø5/16 (SPENCER AIRCRAFT #AN940-516)	1
		B/O	-19	1	HEX HEAD CAP SCREW	STEEL	#10-32 UNF X 7/8 (SPENCER AIRCRAFT #AN3-7A)	1
		B/O	-21	2	ROLL PIN	S.S.	Ø3/32 X 1 (MCMaster-CARR #92373A149)	1
		B/O	-23	4	HELI-COIL	S.S.	5/16-24 UNF X 1/2 (MCMaster-CARR #91732A233)	1
		B/O	-27	4	#2 DRIVE SCREW	COATED STEEL	#2 X 1/4 (MCMaster-CARR #90081A077)	1
		B/O		1	DART PLACARD	ALUMINUM	RB41011	1

DART AEROSPACE	
TITLE T/R PITCH CONTROL LINK ADJUSTING TOOL	
DWG NO: RBW6405G00332-3G	REV 5
MAT'L: UNLESS OTHERWISE SPECIFIED FINISH: DIMENSIONS ARE IN INCHES DECIMAL: .XXX ± .005 FRACTIONS: 1/8 ANGLES: ± 5° SURFACES: ± 125"	
SPEC: 1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: PERRITT CHECKED: CLOUGH APPR: ANDERSON QA APPR: LINDSAY APPROVED: MACKOVJAK SCALE: 1:3	
DATE: 1/13/2008 SHEET 1 OF 7	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043342



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043342

PO Date: 5/1/19

Due Date: 6/26/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1.	194373	RBW6405G00332-3GP			Tail Rotor Pitch Control Adjustment Tool REV 5	Firmed -		6/26/19	2 pcs	0 pcs	2 pcs	\$1,500.00/pcs	\$3,000.00
Grand Total: \$3,000.00													

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 5/1/19 10:45 AM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 25385
Shipment Date: 06-Jun-2019
Ship Via: Pick up at METEC
Order Number: 3786
Order Date: 05/02/19

Customer Code: DART
Phone: (613) 632-9577
PO Number: POHB043342
Terms: Net 60 Days

----- Quantity -----								Job
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Number</u>
1	2	2	0	0	EA	RBW6405G00332-3GP Tail Rotor Pitch Control Adjustment Tool	5	3786-01

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RECEIVED
JUN 06 2019
DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
2	RBW6405G00332-3GP	Tail Rotor Pitch Control Adjustment Tool	5	HB043342

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MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

George Theoret

Vankleek Hill, June 6, 2019